

Date: Thursday, 12/20/2007 3:17:54 PM
 User: Kim Johnston

Process Sheet

2

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI-ACCESS-HANDLE
Job Number	: 36472		
Estimate Number	: 12988		
P.O. Number	:	Part Number	: D205626011
This Issue	: 12/20/2007 S.O. No. :	Drawing Number	: IIN D205-626 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1 / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 33987	Material	:
Written By	:	Due Date	: 1/12/2008 Qty: 4 Um: Each
Checked & Approved By	: <u>Kim Johnston 12 21</u>		
Comment	: Est Rev: B Reformat 00-03-03 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP 205-626-011 CHG 002

08/06/05

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2480011	Handle, Weldment (LH)
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle, Weldment (LH)

Batch: 1556509

500 / 4/1/1/5

4.0	AN526C632R7	Screw
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Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Screw

Batch: 13154 (2x)

17864 (19x)

1106785 (3x)

54

5.0	AN960JD6	Washer
-----	----------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Washer

Batch: 116085

8/2/4 54

(4x)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: P Date: 08/02/06

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/20/2007 3:17:54 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI-ACCESS-HANDLE

Job Number: 36472

Part Number: D205626011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

MS21042L06

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch:

M106612

8/2/4

su

(4X)

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/02/05 (4)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D205-626-011

Location:

PPP Rev:

D

8/2/5

su

(4X)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D08102/06 (4)

Job Completion



2008/2/05 (4)

h

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN B WILLIAMS	DRAWN BY MIKE M	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED BW	APPROVED BW	DRAWING NO. D205-626	REV. B SHEET 1 OF 2
DATE 96:05:14		TITLE HELI-ACCESS-HANDLE	
B	BW	96.08.14	ADD RIGHT HAND HANDLE

Qty -011	Qty -012	Part Number	Description
X		D205-626-011	DOOR HANDLE KIT LH
	X	D205-626-012	DOOR HANDLE KIT RH
1		D2480-011	HANDLE ASSEMBLY
	1	D2480-012	HANDLE ASSEMBLY
6	6	AN526C632R7	SCREW
6	6	AN960JD6	WASHER
6	6	MS21042L06	NUT

GENERAL NOTES:

1. COMPATIBILITY

COMPATIBILITY OF THIS INSTALLATION WITH THE AIRCRAFT IS THE **RESPONSIBILITY OF THE INSTALLER**. ENSURE THAT THIS INSTALLATION DOES NOT CONFLICT WITH A PREVIOUS MODIFICATION.

2. DAILY INSPECTION

CHECK PHYSICAL INTEGRITY AND SECURITY OF THE HANDLE(S) AND ENSURE THAT IT IS SECURELY ATTACHED.

3. WORKMANSHIP

UNLESS OTHERWISE STATED, ALL WORKMANSHIP SHOULD BE TO THE **STANDARD** SET BY THE AIRCRAFT MAINTENANCE MANUAL.

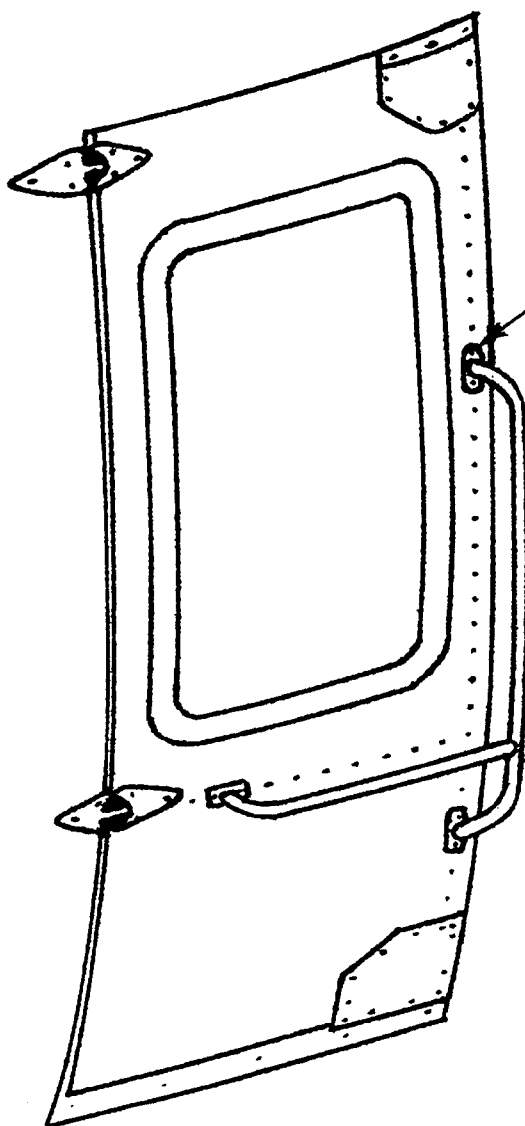
4. WEIGHT AND BALANCE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36472

LATERAL				LONGITUDINAL	
Installation	weight	Arm	Moment	Arm	Moment
D205-626-011 LEFT SIDE	1.3 lb .590 Kg	-46.5 in -1.18 m	-60.45 in-lb -0.697 m-Kg	87.2 in 2.21 m	113.36 in-lb 1.31 m-Kg
D205-626-012 RIGHT SIDE	1.3 lb .590 Kg	46.5 in 1.18 m	60.45 in-lb 0.697 m-Kg	87.2 in 2.21 m	113.36 in-lb 1.31 m-Kg



DESIGN	DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
B WILLIAMS	MIKE M	DRAWING NO.	REV. B
CHECKED BW	APPROVED BW	D205-626	SHEET 2 OF 2
DATE	TITLE		SCALE
96:05:14	HELI-ACCESS-HANDLE		



TRANSFER EXISTING RIVET
LOCATIONS TO HANDLE

AN526C632R7 SCREW (2)
AN960JD6 WASHER (2)
MS21042L06 NUT (2)
(3 PLACES)

D2480 HANDLE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36472

D205-626-011 SHOWN
D205-626-012 OPPOSITE

2

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Photocopy bluefile & type labels per PPP 205-626-011 CHG 002

08.01.10 JA

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	D2480011	Handle, Weldment (LH)
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Handle, Weldment (LH)

Batch: _____

REFERENCE ONLY

4.0	AN526C632R7	Screw
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Screw

Batch: _____

5.0	AN960JD6	Washer
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Comment: Qty.: 6.0000 Each(s)/Unit Total : 24.0000 Each(s)

Washer

Batch: _____